

Date: Thursday, 8/23/2007 11:53:30 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 34245		Part Number	: D33023	
Estimate Number	: 11318		Drawing Number	: D3302 REV B2	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/23/2007 S.O. No. : N/A		Drawing Revision	: B2	
Prshrt Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/3/2007	
Previous Run	: 29943		Qty:	10	
Written By	: JJA		Um:	Each	
Checked & Approved By	: JJA 07.08.23			12	
Comment	: Est A 04.09.02 New issue KJ/JLM			10	
	Est B 06.05.02 Water jet EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S063	6061-T6 .063 Sheet	
		Comment: Qty.: 1.0428 sf(s)/Unit Total : 10.4276 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-3 Batch: M105225	SAD 07/08/25
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3302 Dwg Rev: B2 Prog Rev: B2	
		2-Deburr if necessary	SAD 07/08/25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/08/25
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	Er 07/08/25 612

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34245		Part Number: D33023
Job Number: 		
Seq. #:	Machine Or Operation:	Description:
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <i>07/12/10 (12)</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 <i>SAD 07/12/10 (12)</i>		
6.0	BRAKE NC	NC BRAKE  <i>SB 07/12/11 (12)</i>
Comment: NC BRAKE Form as per Dwg D3302		
7.0	QC5	INSPECT WORK TO CURRENT STEP  <i>07/12/11 (12)</i>
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  <i>07-12-12 (12)</i>
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>07-12-12 (12)</i>		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>07/12/12 (12)</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>07/12/13 (12)</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 235</i> <i>07/12/13 (12)</i>		
11.0	QC21	FINAL INSPECTION/W/O RELEASE  <i>07/12/13 (12)</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>07/12/13 (12)</i>		
Job Completion 		<i>07/12/13 (12)</i> <i>W</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34245
Description: Doubler	Part Number:	D3302-3
Inspection Dwg: D3302	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

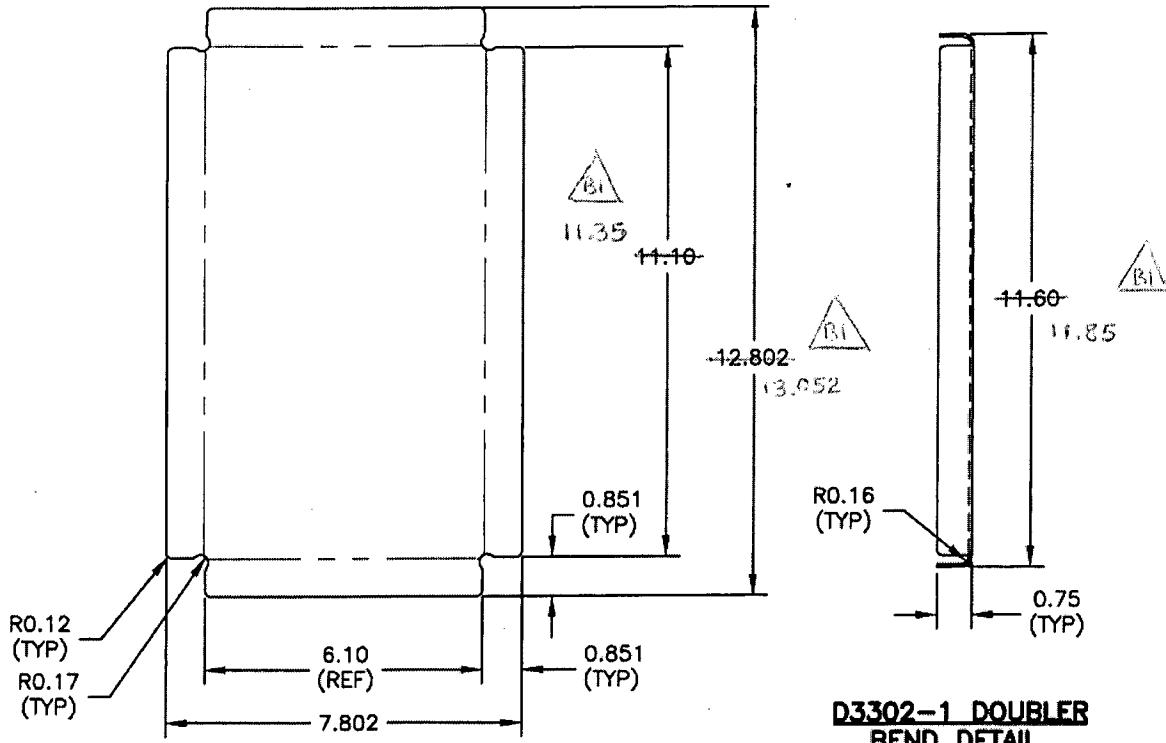
Measured by:	SAN	Audited by:	Er	Prototype Approval:	N/A
Date:	07/08/25	Date:	07/08/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
C	07.01.16	Dimensions revised	KJ/JLM	
D	07.01.29	Dimensions revised	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

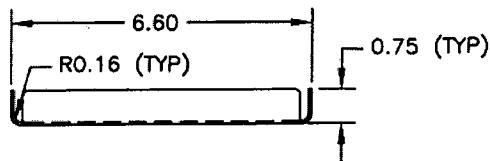
DART

DESIGN <i>TP</i>	DRAWN BY <i>TP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TP</i>	APPROVED <i>TP</i>	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	TP 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	TP 05.03.21	7.25 WAS 7.34; 8.952 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23 *TP*



D3302-1 FLAT PATTERN



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061-T6S-063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

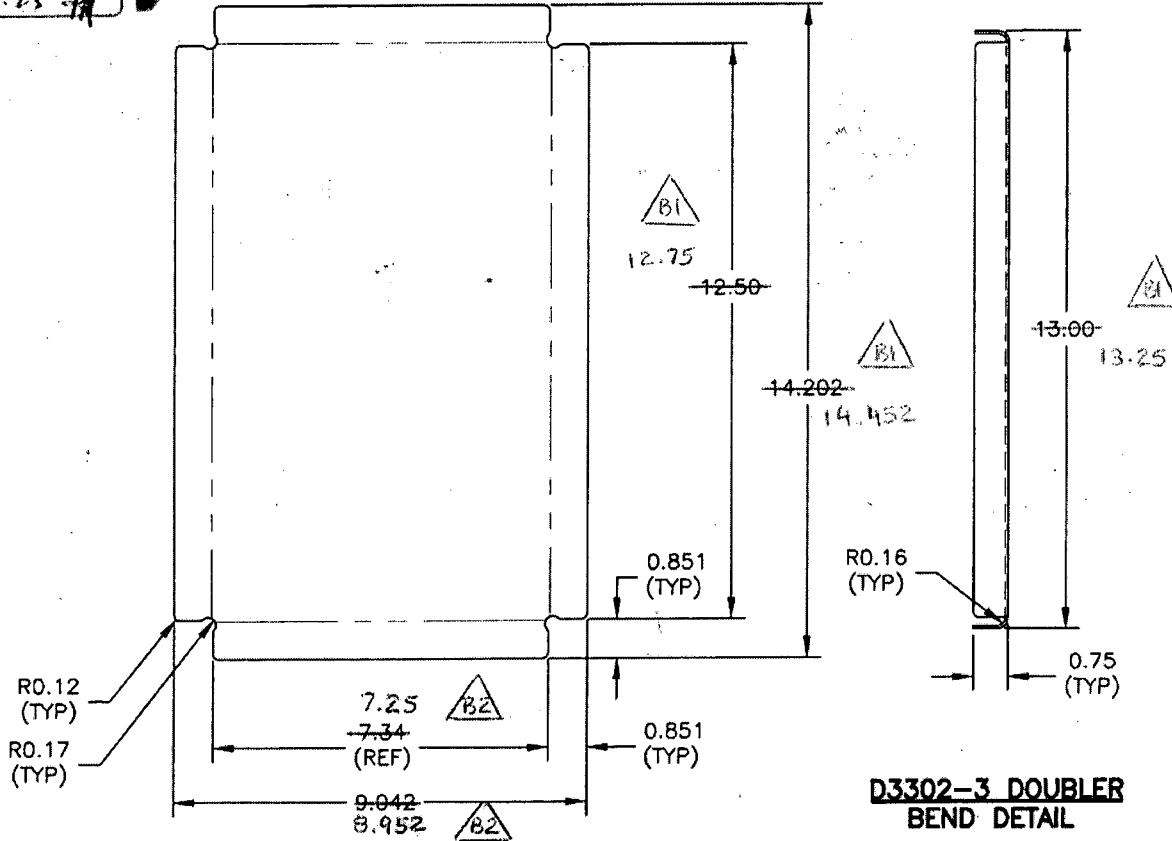
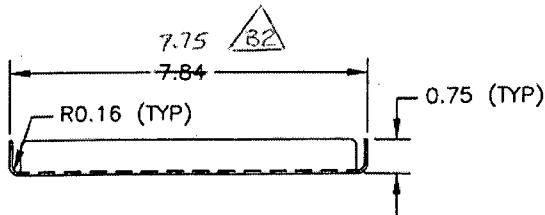
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WORK ORDER
NO. 34245

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	04.11.18	TITLE	SCALE

SHEET 2 OF 4

1:4

RELEASED
04.11.23**D3302-3 FLAT PATTERN****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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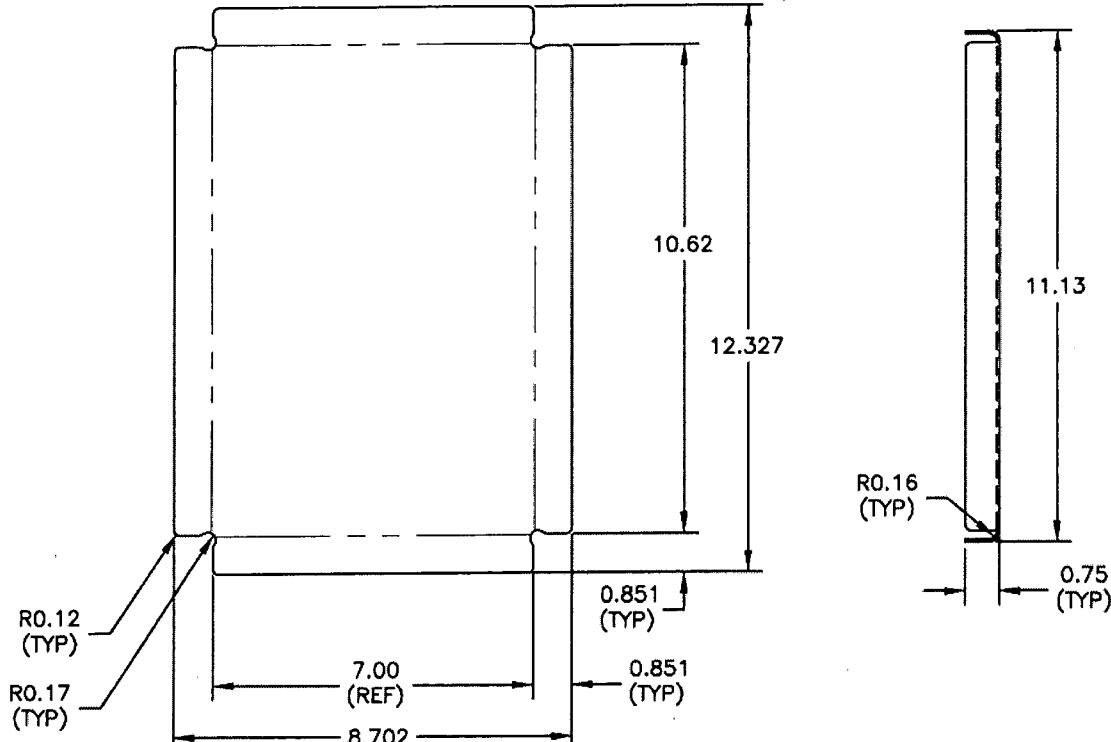
WITHOUT NOTICE

WORK ORDER
NO. 37215



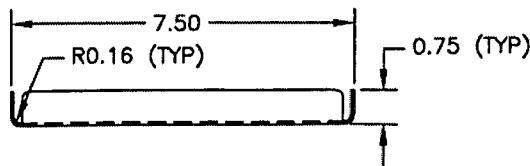
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08	TITLE DOUBLER	SCALE 1:4	

RELEASED
04.11.23



D3302-5 FLAT PATTERN

D3302-5 DOUBLER
BEND DETAIL



D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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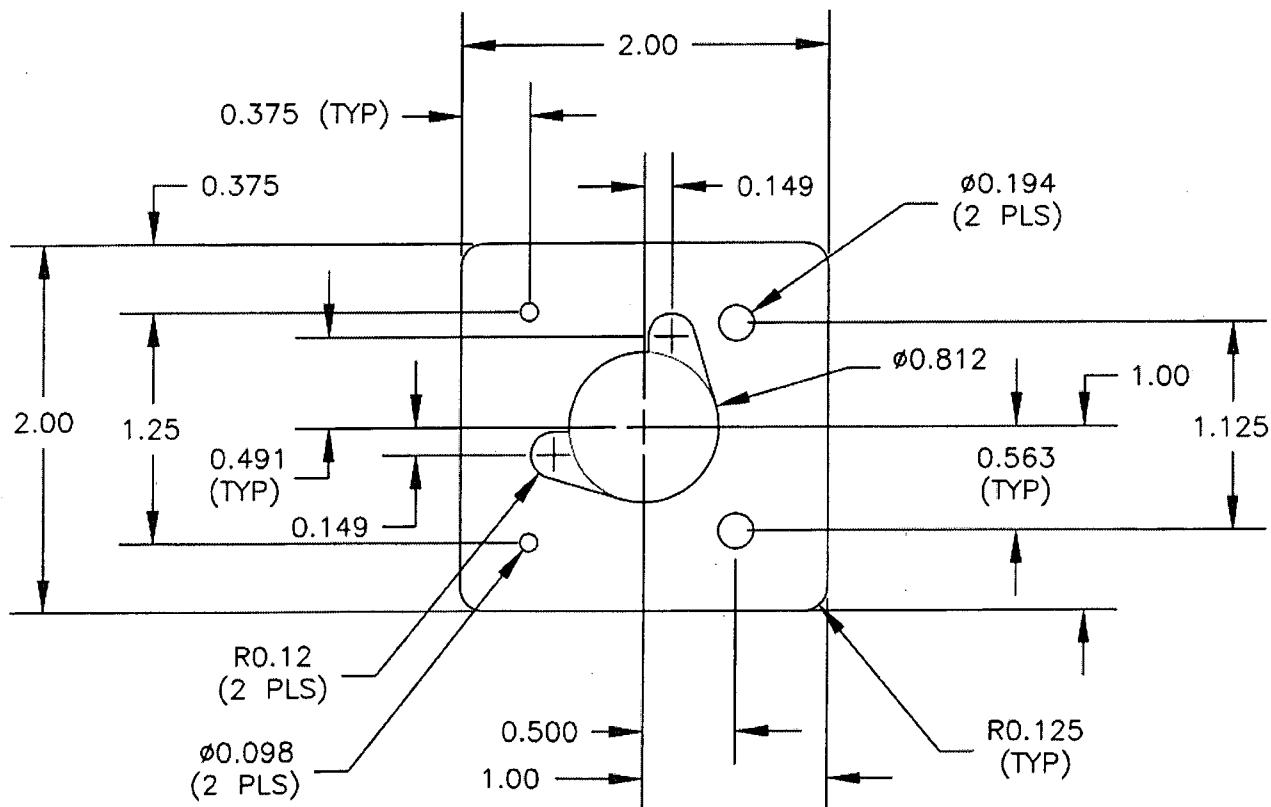
WORK ORDER

NO. 34045



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED RF	APPROVED RF	DRAWING NO. D3302
DATE 04.11.18	TITLE DOUBLER	REV. B SHEET 4 OF 4 SCALE 1:1

RELEASED
04.11.23 ~~RF~~



D3302-7

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO *34545*

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